

DUPLICATE ASAP

Work Order ID 143350

143350

Page 1

Tuesday, April 19, 2016 11:36:39 AM

Item ID: D4165-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Doubler
Start Date: 4/22/2016 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 4/29/2016 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: ME Date: 10-4-19 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: 3-1 SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4165	B								
100		0.00							
100									
Waterjet	Memo	0.40							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.08							
Quality Control									

8 04/16/20

8 04/16/20

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Tuesday, April 19, 2016 11:36:39 AM

143350

Page 2

Item ID: D4165-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 4/22/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.16

Quality Control

DAS
38
9-89
APR 21 2016

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.08

Hand Finishing

8 16-4-21 JH

135

QC7-Inspect Chemical Conversion Coat

0.00

135

QC

Memo

0.08

Quality Control

DAS
38
9-89
APR 21 2016

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Tuesday, April 19, 2016 11:36:39 AM

143350

Page 3

Item ID: D4165-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 4/22/2016 Start Qty: 8.00

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Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <i>St236</i>	0.00							
140						<i>8</i>	<i>APR 22 2016</i>		<i>048</i>
Packaging	Memo	0.08							<i>0</i>
Packaging									<i>0-00</i>
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.80							
Quality Control									

MLJ **APR 25 2016***2m 16/04/22**MLJ* **APR 25 2016**

Picklist Print

Tuesday, April 19, 2016 11:36:38 AM

Page 1

Work Order ID: 143350

143350

Parent Item: D4165-1

D4165-1

Parent Item Name: Doubler

Start Date: 4/22/2016

Required Date: 4/29/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	79.1110	0.353	2.972631			

M2024T3S 040

2024-T3 .040 sheet

**

DC 16/04/20

Location

Loc Qty

Loc Code

MAT022

79.111

m133548

6.74

m134157

0.4

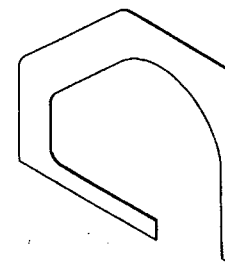
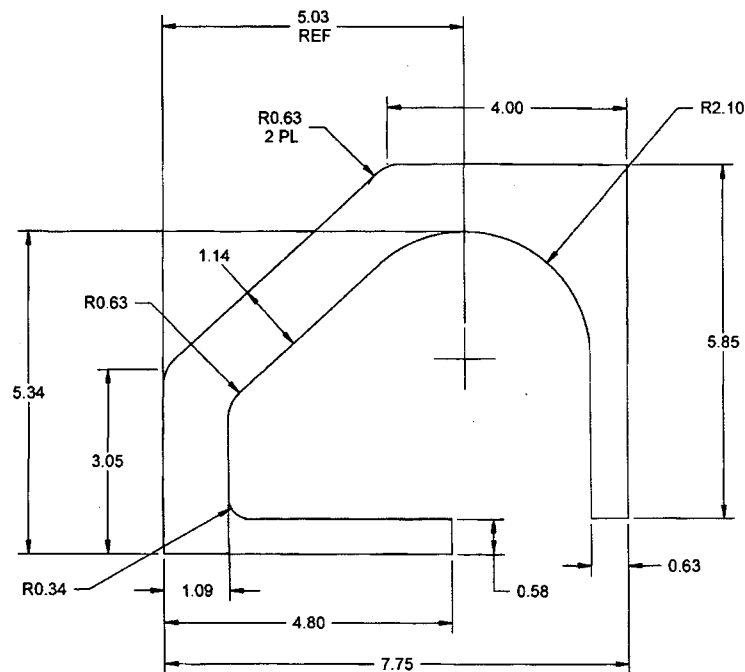
m134399

3.971

m134532

68

3.3



#143350

D4165-1 DOUBLER

RELEASED
2011-04-15
MD

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

B	CORRECTED BEND ORIENTATION ON D4165-9 (ZN C1-5)	RF	11.04.11
A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4165

TITLE
VRD PARTS

SCALE
NTS

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REV. B

SHEET 1 OF 7

